

Date: Thursday, 9/21/2006 3:24:03 PM
 User: Kim Johnston

Process Sheet

| | |
|--|---|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : PLUG |
| Job Number : 28691 | |
| Estimate Number : 10512 | |
| P.O. Number : <i>N/A</i> | Part Number : D26511 |
| This Issue : 9/21/2006 S.O. No. : <i>N/A</i> | Drawing Number : D2651 REV. B |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : <i>N/A</i> Type : MACHINED PARTS | Drawing Revision : B |
| Previous Run : 28400 | Material : <i>N/A</i> |
| Written By : _____ | Due Date : 10/3/2006 Qty: 300 Um: Each |
| Checked & Approved By : <i>J. G. 06 09 21</i> | |
| Comment : Est: A 02.04.15 New Issue NG | |
| Est: B 05.12.12 added deburr EC | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|--------------|-------------------------|
| 1.0 | M6061T6R0500 | 6061-T6 Round Bar .500" |
|-----|--------------|-------------------------|



Comment: Qty.: 0.0421 f(s)/Unit Total: 12.6315 f(s)

Material: 6061-T6 (QQ-A-225/8) 0.500" Dia
 (M6061T6R0500) *16991 x63"*

Batch: *M101421*

J. G. 06/09/23

| | | |
|-----|----------|--------------------------|
| 2.0 | HARDINGE | HARDINGE CNC LATHE SMALL |
|-----|----------|--------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1

1- Turn as per Folio FA219 and Dwg D2651

2- Deburr

J. G. 06/09/23 304

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J. G. 06/09/23 304

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

M8 06/09/25

| | | |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr ias per dwg D2651

FF 06-10-12 304

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: LD Date: 06/11/07
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 9/21/2006 3:24:03 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 28691

Part Number: D26511

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



counted



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

YK

06/10/14 X 304

7.0

POWDER COATING

POWDER COATING



M101575



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3
(Only larger section necessary)

YK

06/11/06 X 304

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

Q.M

06/11/06

X 304

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: FP

Q.M 06/11/06

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

304
06/11/07

Job Completion



W 06/11/07

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

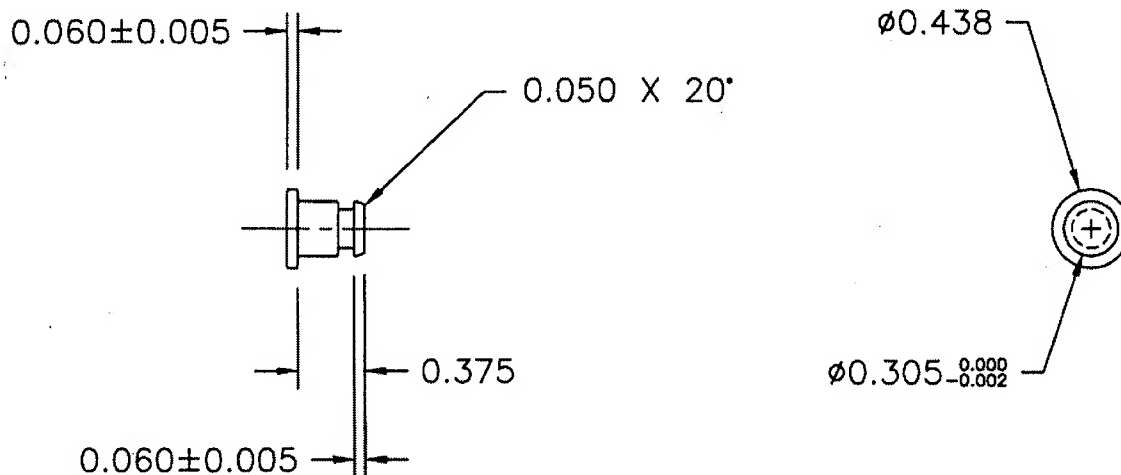


| | | | |
|------------------|---------------|---|------------------------|
| DESIGN # | DRAWN BY # | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D2651 | REV. B SHEET 1 OF 1 |
| DATE 03.12.19 | | TITLE PLUG | SCALE 1:1 |
| A | 97.03.25 | NEW ISSUE | |
| B | 03.12.19 | ADD POWDER COAT, MS28775-008 | |

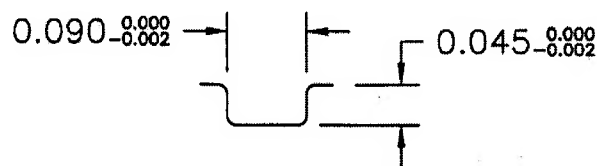
RELEASED

03.12.19

D2651-1 PLUG:



GROOVE DETAIL (SCALE 5:1)



D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER
3/16 ID, 5/16 OD, 1/16 WIDTH
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

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